

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-ROTOR BRAKE KIT		
Job Number	: 43178			Part Number	: D38213		
Estimate Number	: 13584			Drawing Number	: D38213 UNDER REVIEW 08.11.25 18		
P.O. Number	:			Project Number	: IN0002		
This Issue	: 04/11/2008	S.O. No. :		Drawing Revision	: A UNDER REVIEW		
Prsht Rev.	: NC			Material	: MKYDEX6185S80P362015		
First Issue	: / /	Type	: R&D THERMOFORMING		Due Date	: 14/11/2008 Qty: 2 Um: EACH	
Previous Run	: 42066						
Written By	:						
Checked & Approved By	:						
Comment	: Est. A New Issue 08/09/17 DL						

## Additional Product

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
04/11/2008 WH

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MKYDEX6185S80P362015	Kydex velour matte, ivory
Comment: Qty.: 13.2489 sf(s)/Unit Total : 26.4978 sf(s) <u>M109703</u>		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING <u>08/11/04 WH</u>		
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING <u>x2</u>		
4.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE <u>08/11/04 WH</u>		
Thermoform as per Dwg. D3821-3 and folio (FTA 9054 Prototype ) using tool DT 9054		
Dwg. Rev. <u>A UNDER REVIEW</u> Folio Rev. <u>A</u> <u>08/11/04 DH</u>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>x2</u> Visually inspect for proper formation of each part <u>08/11/04 WH</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:  
User:

Tuesday, 04/11/2008 8:34:04 AM  
Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL--ROTOR BRAKE KIT

Job Number: 43178

Part Number: D38213

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC8	SECOND CHECK <i>BBO8/11/17</i>
7.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
		Comment: HAND FINISHING THERMOFORMING
	1) Trim to Finished Dimensions	<i>BBO8/11/17 x2</i>
8.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
		Check dimensions to ensure conformity to drawing tolerances.
9.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
		<b>ENGINEERING APPROVAL</b> <i>P# 08.12.01</i>
10.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____
		<i>N/A NOT FOR STOCK</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE
		Comment: FINAL INSPECTION/W/O RELEASE <i>108.12.01 Prototype</i>
		Job Completion
		<i>✓ 08.12.04</i>
		<del>POSITIVE RECALL EFFECTIVE 08.11.04 AUTH L4 RELEASED _____ DATE _____</del>

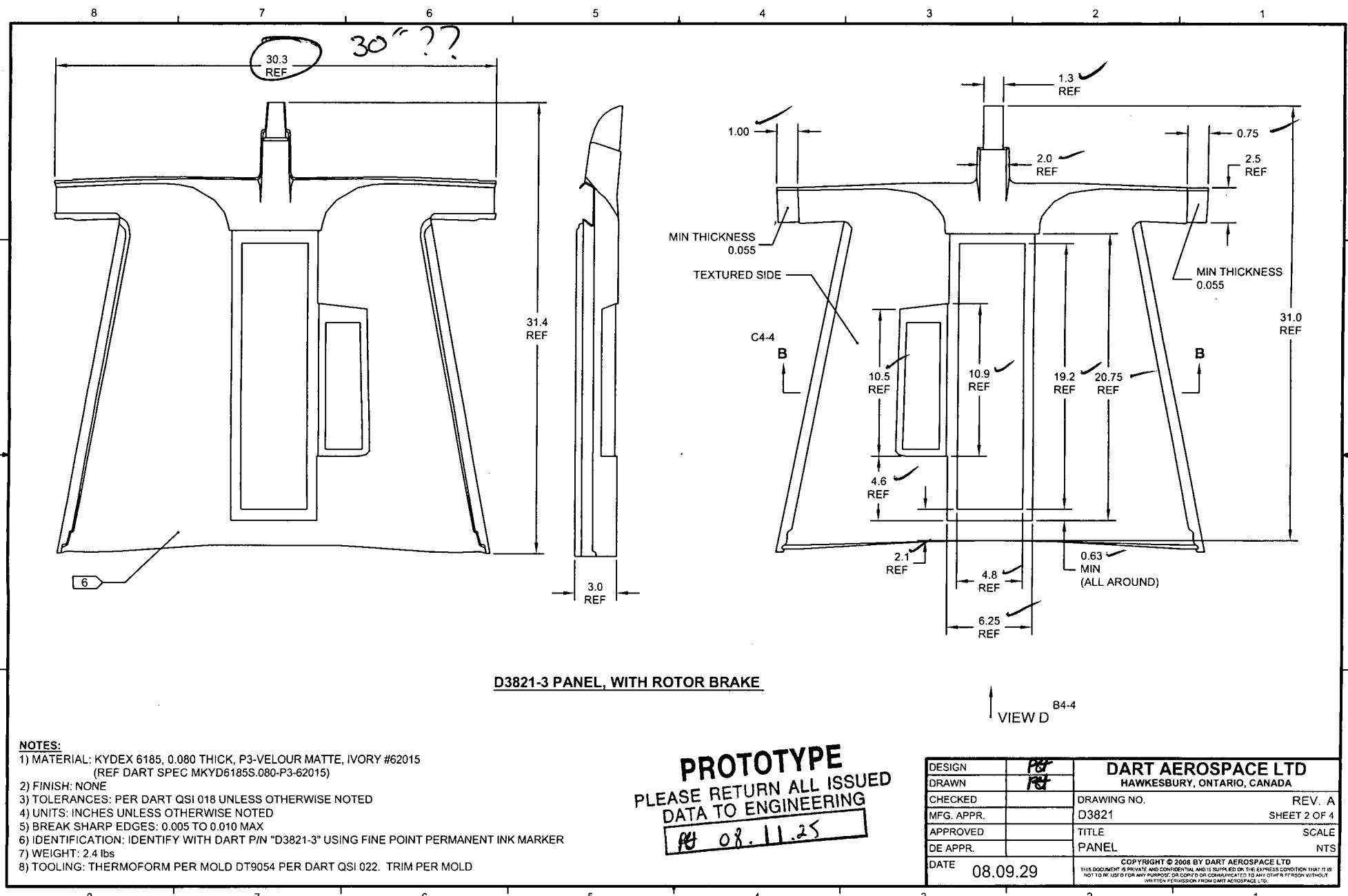
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

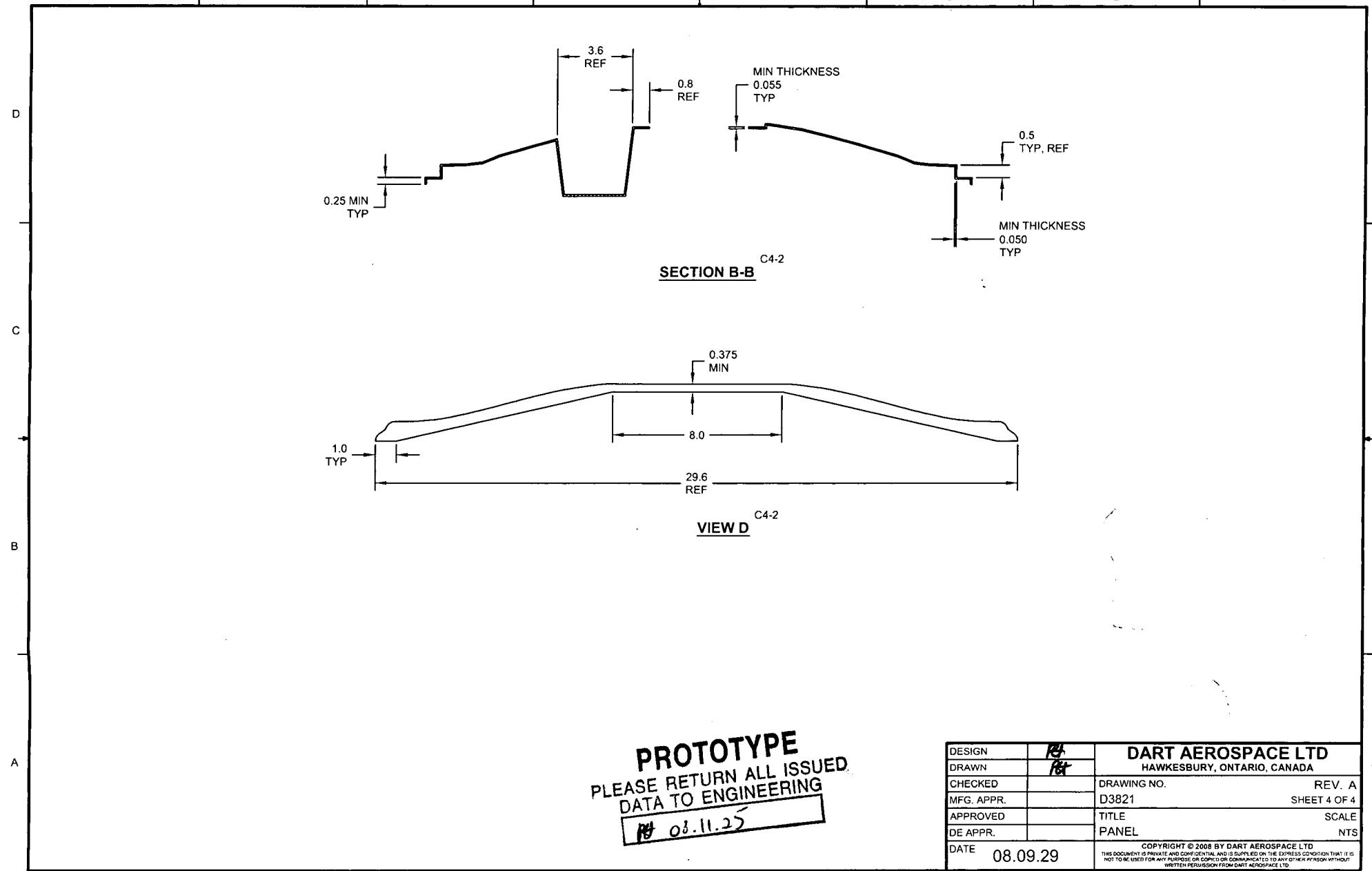
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 7 6 5 4 3 2 1



DESIGN	RE	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3821	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.09.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

## Receiving Report

Date:

8/10/24

Batch No:

M109703

Supplier:

SABRC

Dart P/O:

7280

Packing Slip: Yes  No   
Invoice: Yes  No   
Receipt: Cash  Cr

Release Note Attached: Yes  No  N/A   
Waybill Attached: Yes  No   
Shipment Complete: Yes  No  N/A   
QC6 Inspection: OK  N/A   
Work Order: OK  N/A

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12       

Admin:

Location



**SABIC Polymershapes**

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

## CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # :1

QUANTITY: 51

54 *Sabic/27*

*S*  
*08/027*

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS  
OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE  
PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND  
LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

*Jon Caldwell*

JON CALDWELL  
BRANCH MANAGER

DART AEROSPACE LTD	Work Order:	43178
Description: Panel - with Rotor Brake / Prototype.	Part Number:	D 3821-3
Inspection Dwg: D 3821 Rev: A	Page 1 of 1	1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *BB*

Date: 08/11/27

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.55 (Ref)	min	0.060	✓			
0.63 (Ref)	min	0.63	✓			
4.8 (Ref)		4.8	✓			
19.2 (Ref)		19.25	✓			
10.9 (Ref)		10.9	✓			
10.5 (Ref)		10.5	✓			
4.6 (Ref)		4.63	✓			
2.1 (Ref)		2.065	✓			2.1 on other side
6.25 (Ref)		6.25	✓			From TOP Radius.
20.75 (Ref)		20.75	✓			"
2.0 (Ref)		2.0	✓			"
1.3 (Ref)		1.313	✓			

Measured by: *BB*

Date: 08/11/27

Audited by: *BB*

Date: 08/11/27

Prototype Approval: *BB*

Date: 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	43178
Description: Panel - with Rotor Brake / Prototype	Part Number:	03821-3
Inspection Dwg: D3821 Rev: A		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			

Measured by: *BB*

Date: 08/11/27

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/- 0.030	0.768	/			
1.00	+/- 0.030	1.00	/			
2.5 (ref)		2.568	/			
31.0 (ref)		31.032	/			
30.3 (ref)		30.		/		Too much flex, set minimum 30"
29.6 (ref)		29.6	/			

Measured by: *BB*

Date: 08/11/27

Audited by: *J*

Date: 08/11/27

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	